



Dart Aerospace Ltd.
1270 Aberdeen St
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D2365
Job Sheet 196653



Part No: D2365

Job Qty: 20 pcs

Part Name: Wearplate Pip Pin



Part Weight: 0 lbs

Job Created: 6/18/19

Due Date: 7/12/19

Type: Stock

DAS
21
9-89

Status: New

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Priority: Medium

Note: DWG REV C IPP Rev A Removed from 9 Dlglt 05-12-05 JLM (IPP Rev:B Now On Waterjet 08-04-04 JLM
Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs		7/12/19	0.02	0.58	Waterjet - Flow		
120	QC 8	20 pcs		7/12/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Handfinish - 1-1 Chemical-B4B	20 pcs		7/12/19	0.00	0.40	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		

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Container No: S220010

Part: D2365

Job No: 196653

Serial No/Batch: S220010

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/04/19

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				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
140	QC 7	20	7/12/19	0.00 0.00	QC 7 - 10
		pcs			QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50
					QC 7 - 67
					QC 7 - 40
					QC 7 - 24
					QC 7 - 43
150	Small Fab - 2 - B4B	20	7/12/19	0.00 0.46	Small Fab - 1 - B4B
		pcs			Small Fab - 2 - B4B

DAS
58
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OCT 09 2019

DAS
58
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OCT 09 2019

160 QC 5	20 pcs	7/12/19	0.00 0.00	Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
170 Packaging 3-1 - Stock - B4B	20 pcs	7/12/19	0.00 0.00	QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
180 QC 21 - SA	20	7/12/19	0.00 0.00	Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				QC 21 - SA - 21	

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OCT 09 2019 10:09-89

PC ST006

DAS

21

5-28

69/6

XZ

JSA

OCT 10 2019

pcs

QC 21 - SA - 70

QC 21 - SA - 53

Part Op 100 - 1-Cut as per Dwg D2365

Descriptions: 120 - (QC8- Inspect parts - second check)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC7-Inspect Chemical Conversion Coat)

150 - (Small Fab) Install Insert as per Dwg D2365

160 - (QC5- Inspect part completeness to step on W/O)

170 - (Identify as per dwg & Stock Location: _____)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.063	6061-T6 .063 Sheet	.0940 sf (.0047 ea)	100-Waterjet - Flow - 1	5152151
FE-832-EF	Pem Insert D3996-FE-832-EF	40 Ea (2 ea)	150-Small Fab - 2 - B4B	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.063	0	554	0
150-Small Fab - 2 - B4B	FE-832-EF	40	252	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wear Plate	1.250Inches ± 0.010	1.260 1.240		
2	Wear Plate	1.000Inches ± 0.010	1.010 0.990		
3	Wear Plate	0.625Inches ± 0.010	0.635 0.615		
4	Wear Plate	0.250Inches ± 0.010	0.260 0.240		
5	Wear Plate	0.500Inches ± 0.010	0.510 0.490		
6	Wear Plate	0.125Inches ± 0.010	0.135 0.115	Radius	
7	Wear Plate	0.290Inches + 0.006 - 0.001	0.296 0.289	Diameter	
8	Wear Plate	0.191Inches + 0.006 - 0.001	0.197 0.190	Diameter	

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